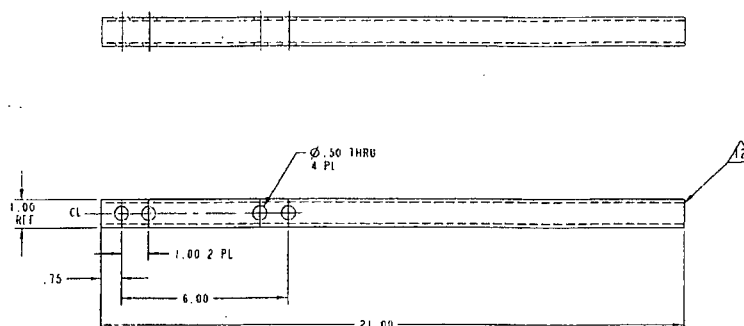
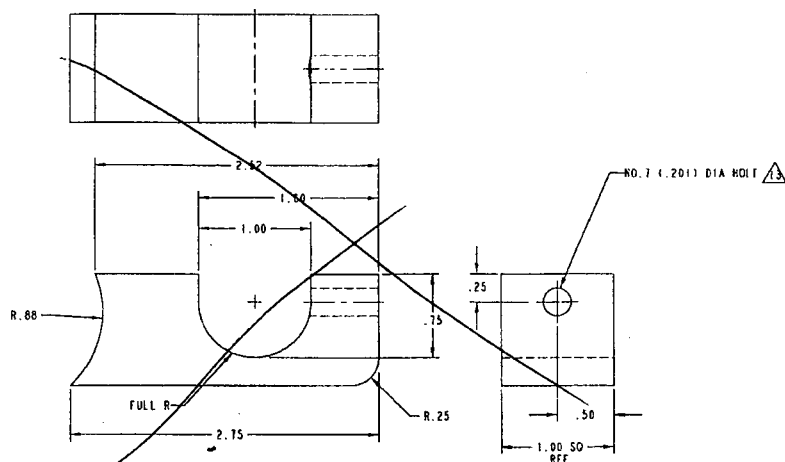


RELEASED
06-11-20



① -239 SQUARE TUBE
MATL: 1.00 SO 7.125 WALL, 6061-T6
QD-A-200/8
SCALE 0.500

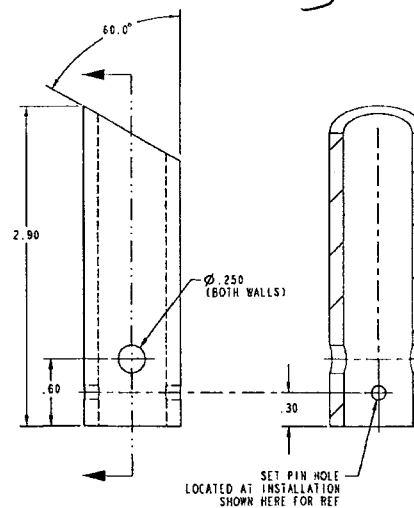
40555



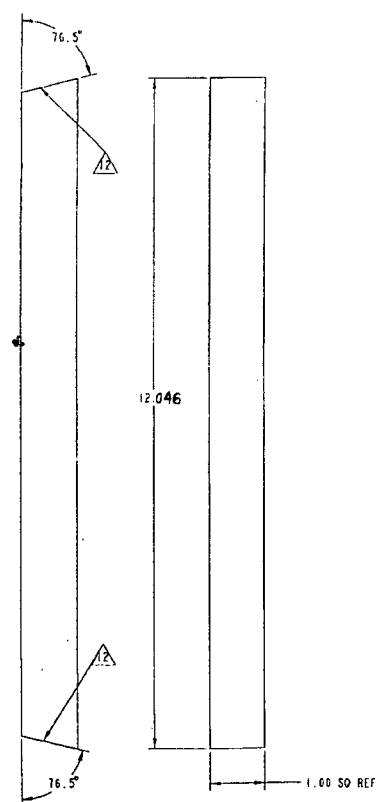
① -241 TUBE DETENT CLIP
MATL: 1.00 SO, 6061-T6
QD-A-200/8
SCALE 2.000

SUPERCEDED BY

① 23440-9



① -243 TUBE HANDLE EXTENSION
MATL: .875 OD X .125 WALL, 6061-T6
QD-A-200/8
SCALE 2.000



① -139 SQUARE TUBE
MATL: 1.00 SO X .125 WALL, 6061-T6
QD-A-200/8
SCALE 1.000

PREMIER AVIATION, INC.
2002 Aviation Parkway, Grand Prairie, Texas 75052
SIZE CODE IDENT NO. QND NO. REV.
D105UV8 B67-43001 B1
SCALE: 1/16" = 1" SHEET 21 OF 45

ORIGINAL

Date: Wednesday, 16/07/2008 9:19:14 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SQUARE TUBE

Job Number: 40555

Part Number: PB6743001239

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

batch: B 40272 ✓

SP 08-07-28 (12x)

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Square Cap

batch: B 40042 ✓

SP 08-07-28 (3x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

SP 08-07-28 (30x)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SP 08-07-28 (3x)

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/07/28

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/28

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

08-07-31 3

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/07
mf 08-08-06

Date: Wednesday, 16/07/2008 9:19:14 AM
User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SQUARE TUBE
Job Number	: 40555		
Estimate Number	: 13421		
P.O. Number	:	Part Number	: PB6743001239
This Issue	: 16/07/2008 S.O. No. :	Drawing Number	: B6743001 P.6/P.21
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 23/07/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>mf 08-07-16</u>		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6TS1000W125	6061T6 SQ TUBE 1.00X.125
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Comment: Qty.: 1.8375 f(s)/Unit Total: 5.5125 f(s)

6061T6 SQ TUBE 1.00X.125

batch: M108626

SAD

08/07/17

(3)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.090" chamfer on both ends of tube
- 3- deburr

SAD

08/07/17

(2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/07/17 (2)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

- 1- drill holes as per dwg
- 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes
- 3- deburr

JL 08/07/26

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 08/07/26 (2)